Work Orde May-01-13 7:08		00952		*100	1952*							Page 1	
Revision ID:	D2976 BO 105 Skid	Itube I Beam	A	Accept	*N900	0040	100)*	Setup	Start Stop	*N:	S1* S2*	
Required Date:	4/30/13 4/30/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item Customer:								
Reference: Approvals:	Process P	lan: MU5	Date: \3-05-03	Tooling:		Date:			Run	Start	*N	R1*	•
:	QC:		Date:	SPC (Y/N):	r	Date:			•	Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp	
Draw Nbr	Re	evision Nbr							,				
D2976	Re	ev A1									•		3
្វីរ៉ឺ្ *1∩∩*	74.44	Skidtubes		0.00	47.0 (48.0)				~	L.		•	
Skidtubes		Memo		0.00					T	5 /		1307	t-1.
Skidtubes			-084 extrusion to length: (82. holes to finish size per dwg D		drill pilot					R		\ \ <i>\</i> \ <i>\</i>	فلقر وسير
110		Chemical Conversion Co	oat per QSI005 4.1	0.00									
HandFinish Hand Finishing		Memo		0.00					_	D		500	J-7-
								•		/	/		
120		QC5- Inspect part comp	leteness to step on W/O	0.00								_ ,	
120 QC Quality Control		Memo	, s	0.00				2	<u> </u>	· 		B13/47	' <i>l</i> 17

DQA: _____Date: _____

NCR: Y	/es / 1	lo			WORK ORDER NON-C		NFORN	/IANCE / UPD	ATE					
											QA Closed:	Da	ite:	
Work Orde	er:				DISPOSITION	1					PARTMENT/			
Part N NCR N					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root Cause	Da	te Step	Qty		ption of work order update or Non-conformance	1	Initial nief Eng	Actic Descrip			Sign & Date	Verificatio	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
					F.	AUI	LT CATE	GORY						
Landi	ng Gear			·	General		-			_	1			1
	Cracl Crusl Cuffs Heat	re Not Conce rs ned/Crimped	I .	D/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		-i '	ion Incomplete ions Incomplete/Ui enance eled	nclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Ripp	es in Bend			Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Order ID 100952 *100952* Page 2 May-01-13 7:08:57 AM Accept *N900040100* Item ID: D2976 Setup Start **Revision ID:** Stop BO 105 Skidtube I Beam Item Name: Start Qty: 2.00 **Start Date:** 4/30/13 Cust Item ID: Required Date: 4/30/13 **Req'd Qty:** 2.00 **Customer:** Reference: Run Date: Process Plan: Tooling: Date: Approvals: Stop Date: SPC (Y/N): QC: Date: Reject Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Number Stamp Description Code Qty Qty **Work Center ID Run Hours** Identify as per dwg & Stock Location: 0.00 130 *130* 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 140 MCJ 13-07-17 *140* 0.00 QC

Memo

Quality Control

DQA:

Date:

NCR:	/es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	PDATE			
											QA Closed:	Date:	
Vork Orde	or.					DISPOSITION				. AGAINST DE	PARTMENT/	PROCESS	
Part I					. •	Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR I	No.					Work Order Update		1	Large Fab	Composite]	Supplier	
Root		,			Descri	iption of work order update	\top	nitial	A	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
oc/Data													
quip/Tooling													
perator							ĺ						
laterial													
etup													
ther													
rocess							ļ						
upplier													
raining													
napproved			<u> </u>	<u> </u>				_			<u> </u>		
							FAUI	T CATE	GORY				
Landi	ng (1				General		1		_	¬ ·		-
		Bending				Bend	\perp	Grain			Ovalized		Pressure/Forced
	L	Centre No	ot Conce	ntric to	o/s	BOM/Route	_	Hardwa		<u> </u>	Over/Under	 	Temperature/Cure
		Cracks				Broken/Damaged		4	ion Incomplete	<u> </u>	Part Incorre	<u> </u>	Weld
		Crushed/	Crimped.			Burrs		4	ions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination	L	Mainte			Part Moved		
	L	Heat Trea	at			Countersink		Mislabe	eled		Positioned V		_
	L	Inspection	n Strip in	Tube	L	Cut Too Short		Misread	d .		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	/aves in E	Extrusio	n _	Drawing	L	Out of	Calibration				
		Turning S	equence			Finish		Out of	Sequence				
		Wave/Tw	ist in Tul	be		Folio		Outside	Dimensions				

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Picklist Print

May-01-13 7:08:56 AM

Work Order ID:

100952

Parent Item:

D2976

Parent Item Name:

BO 105 Skidtube I Beam

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP C02.10.30Re-formatKJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2963-084		Manufactured	No			110	Each	74.0000	1	2			
Extrusion									41				

 Location
 Loc Oty
 Loc Code

 HALL
 74

 14459
 74

15-04-15

Page 1

		~								••,	DC	{Α: _	Date:		
NCR: Y	'es	/ · No		•			WORK ORDER NON-C	ON	IFORM	MANCE / UPDATE	QA Clos	ed:	Date:		
Nork Orde	ır.						DISPOSITION			AGAINST D	EPARTME	NT/	PROCESS		
Part N	Part No					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstul Machining Small Formation Thermoforming Finishing Large Fab Composi		prod. Rec/Store		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other		
Root			+	÷	Desc	crir	otion of work order update		nitial	Action	Sign 8				
Cause	≥ -	Date	Step	Qty			r Non-conformance	1	ief Eng	Description	Date		Verification	QC Inspector	
oc/Data quip/Tooling perator flaterial etup other rocess upplier training							•		·					_	
							F/	AUL	T CATE	GORY					
Landi	ng (Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in Torque W	Crimped at n Strip in Bend Javes in E	Tube			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misrea Offset Out of	tion Incomplete tions Incomplete/Unclear enance eled d Calibration	Ovalized Over/Ur Part Inco Part Los Part Mo Position Power L	orrect/Mi ved ed V	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
	Turning Sequence					1	Finish		Out of	Sequence					

Outside Dimensions

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Wave/Twist in Tube

Folio



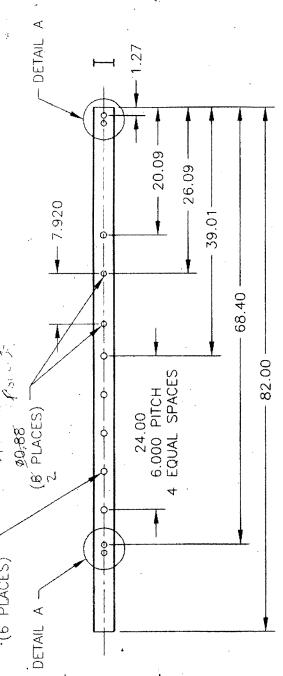
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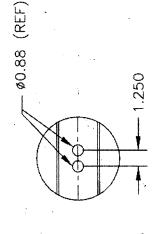


18. E. W

	RF	DRAWN BY	DART AEROSPACE BELLEVUE, WA	USA,	INC.
CHEC	KED	APPROVED	DRAWING NO	<u> </u>	REV. A
1	#	Wall to the	D2976	SHE	EET 1 OF 1
DATE	······································		TITLE		SCALE
00.	03.14		WEB .		1:14
Α		00.03.14	NEW ISSUE		
AI		01-01-29	OPEN GROUND HAMDLING HOLES	TO \$1.0	e)

ELEASE OD.OS.11





MAKE FROM D2963-084 EXTRUSION FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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